

Split

5/25

DART AEROSPACE LTD		23284
Description: Fuel Purge Canister		D3262-041
Dwg: D3262 Rev. B		20
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: (1) D3262-041 consists of (1) D3262-1	JL	05.05.00	20
2	MV	Cut (2) blanks per (1) D3262-041 Cut blanks: 8.000" x 0.500" x 5.400" long Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) (M6061T6B0.500x05.400) Identify for D3262-3	JL	05/03/07	20
3	MV	Machine as per Folio FA457 and Dwg D3262 Identify as D3262-3	JL	05/03/07	20
4	QC2	Inspect parts as they come off the CNC machine	JL	05/03/07	20
5	QC8	Second check	JL	05/03/07	20
6	MV	Deburr	JL	05/03/07	20
7	MV	Cut D3262-1 to length as per Dwg D3262 Material: 6061-T6 (QQ-A-200/8 or 225/8) 5.00 OD x 0.125" wall (M6061T6T5.000x05.125) Identify as D3262-1	JL	05/03/07	20
8	WA	Weld canister assembly as per Dwg D3262 using JT 3739 to align fillings Pick: Qty Part Number Description Batch A/R Aluminum Rod 7192	JL	05/03/07	20
9	QC9/5	Inspect weld and work to Step 8	JL	06/05/03	20
10	QC5	Pressurize canister to 10 psi and submerge under water and check for leaks as per Dwg D3262.	JL	06.05.03	3
11	FP	Chemical Conversion Coat as per QSI 005 4.1	FL	06 05 03	3
12	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3 Ensure to mask threads	DL	06/05/04	3
13	QC3	Inspect Powder Coat	DL	06/05/04	3
14	ST	Identify with Dart part number and batch number using a fine point permanent ink marker, then Stock	DL	06/05/04	3
15	AC	Cost / part:	DL	06.05.05	3
16	DC	Close W/O Inspect Level 21	DL	06/05/05	3

Rev	Date	Change	Revised By	Approved
A	04.09.02	New issue	KJ/JLM	
B	04.09.29	Added Steps 10-12; changed Step 16	KJ/JLM	
C	05.03.10	Removed P/O for liquid penetrant inspection	KJ/JLM	

RELEASED

Date: Monday, 12/12/2005 8:31:51 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FUEL PURGE CANISTER
Job Number	: 23284		
Estimate Number	: 10440		
P.O. Number	:	Part Number	: D3262041
This Issue	: 12/12/2005	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3262 REV B
First Issue	: 11/14/2005	Project Number	:
Previous Run	:	Drawing Revision	: B
	Type : MACHINED PARTS	Material	:
Written By	:	Due Date	: 11/30/2005
Checked & Approved By	:	Qty:	3
Comment	: Est. C 05.03.10 Removed P/O for liquid penetrant inspection K. J/JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	23284A	FUEL PURGE CANISTER
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Comment: Sub-Component FUEL PURGE CANISTER

2.0	23284B	FUEL PURGE CANISTER
-----	--------	---------------------



Comment: Sub-Component FUEL PURGE CANISTER

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Weld canister assembly as per Dwg D3262 using DT8739 to align fillings

Pick: Qty Part Number Description Batch

A/R Aluminum Rod

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

1-Inspect weld and work to Step 8

2-Pressurize canister to 10 psi and submerge under water and check for leaks as per Dwg D3262.

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Date: Monday, 12/12/2005 8:31:52 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 23284

Part Number: D3262041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

1-Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

2-Ensure to mask threads

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
-----	-----	-----------------------------------------



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: _____

9.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Date: Monday, 12/12/2005 8:31:55 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FUEL PURGE CANISTER
Job Number	: 23284A		
Estimate Number	: 10441		
P.O. Number	:	Part Number	: D32621
This Issue	: 12/12/2005	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3262 REV B
First Issue	: 11/14/2005	Project Number	:
Previous Run	:	Drawing Revision	: B
	Type : MACHINED PARTS	Material	:
Written By	:	Due Date	: 11/30/2005
Checked & Approved By	:	Qty:	3
Comment	: Est. C 05.03.10 Removed P/O for liquid penetrant inspection K J/JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T5000W125	6061-T6 Tube 5.00X.125W
-----	------------------	-------------------------



Comment: Qty.: 0.9406 f(s)/Unit Total : 2.8218 f(s)
 Material: 6061-T6 (QQ-A-200/8 or 225/8) 5.00 OD x 0.125" wall(
 M6061T6T5.000W.125)
 Batch: _____

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut D3262-1 to length as per Dwg D3262
 Identify as D3262-1

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

Date: Monday, 12/12/2005 8:31:55 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 23284A

Part Number: D32621

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

Ensure to mask threads

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: _____

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Date: Monday, 12/12/2005 8:31:58 AM
User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FUEL PURGE CANISTER
Job Number :	23284B		
Estimate Number :	10442		
P.O. Number :		Part Number :	D32623
This Issue :	12/12/2005	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3262 REV B
First Issue :	11/14/2005	Project Number :	
Previous Run :		Drawing Revision :	B
	Type :	Material :	
	MACHINED PARTS	Due Date :	11/30/2005
Written By :		Qty:	6
Checked & Approved By :		Um:	Each
Comment :	Est. C 05.03.10 Removed P/O for liquid penetrant inspection K J/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
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Comment: Qty.: 0.9668 f(s)/Unit Total : 5.8010 f(s)
Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick
(M6061T6B0.500x06.000)
Batch: _____

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
Cut blanks: 6.000" x 0.500" x 5.400" long Bar
Machine as per Folio FA457 and Dwg D3262
Identify for D3262-3
Deburr

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

Date: Monday, 12/12/2005 8:31:59 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 23284B

Part Number: D32623

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

Ensure to mask threads

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
-----	-----	-----------------------------------------



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: _____

9.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

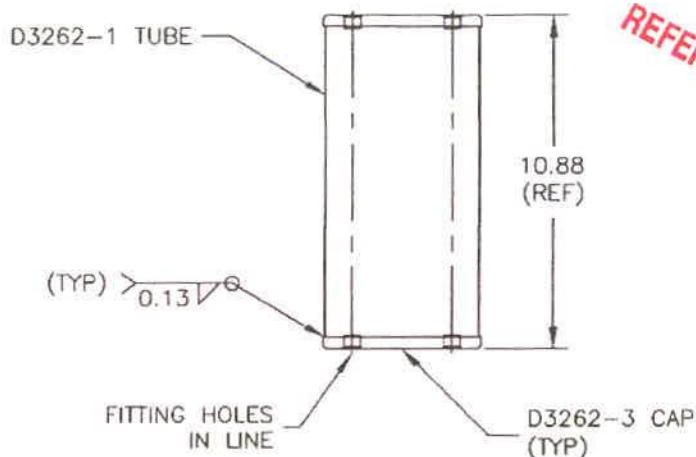
Job Completion



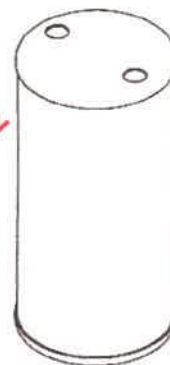
DART

DESIGN R	DRAWN BY R	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED R	APPROVED R	DRAWING NO. D3262	REV. B SHEET 1 OF 2
DATE 05.02.14		TITLE FUEL PURGE CANISTER	SCALE 1:1
A	04.05.06	NEW ISSUE	
B	05.02.14	ADD PRESSURE TESTING OPTION	

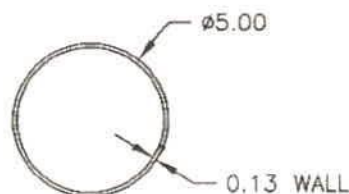
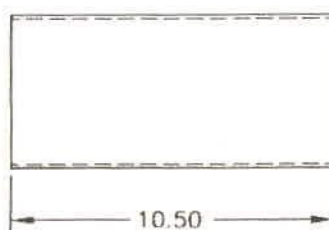
RELEASED
05.02.14



REFERENCE ONLY



D3262-041 CANISTER ASSEMBLY



1 D3262-1 TUBE

D3262-041:

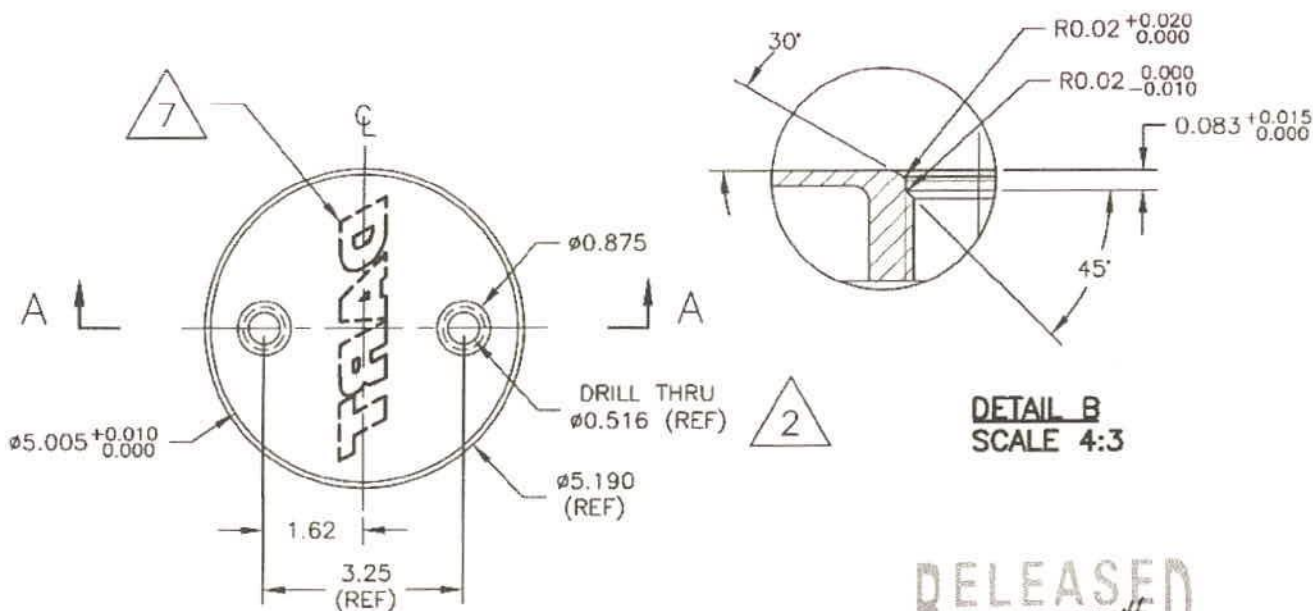
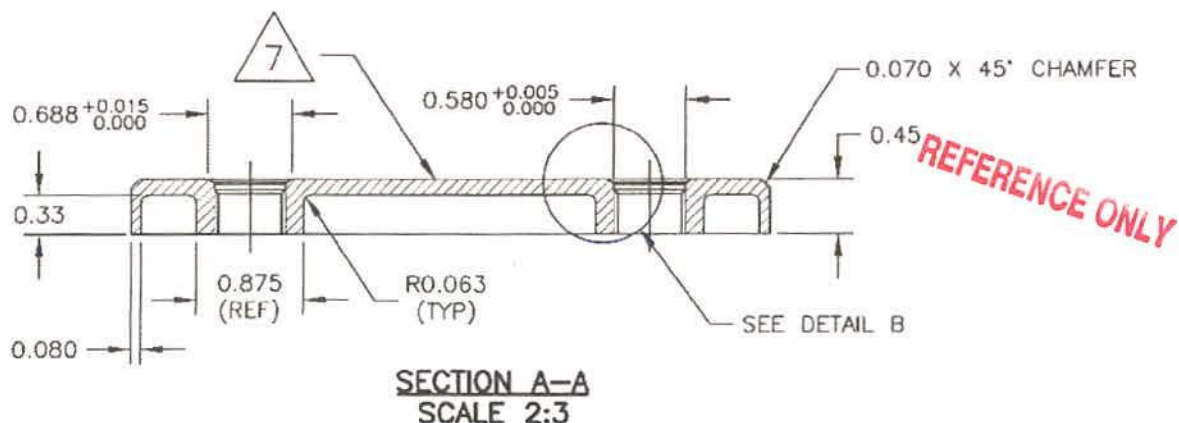
- 1) MATERIAL: 6061-T6 (WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8)
TUBING 5.00 OD x 0.125 WALL (6061T6T5.000W.125)
- 2) WELD PER QSI 004.
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi
AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 8) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

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DART

DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3262	REV. B SHEET 2 OF 2
DATE 05.02.14	TITLE FUEL PURGE CANISTER		SCALE 1:3

**D3262-3 CAP****D3262-3**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR
(REF. DART SPEC. M6061T6B)
- 2) TAP HOLE 9/16-18 UNF-3B PER MIL-S-8879
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP
(MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
10:27 am

Work Order No : 0023284
Project Name : D3262-041
Project For : WK525
Work Order Type : Main
Main WO Number :
House Part Number : D3262-041
Description : Fuel Purge Canister
Manufactured : Yes
Amount Req'd : 20
Amount Done : 17
Start Date : 05-12-05
Est Finish Date : 06-23-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
Part/All Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	383.11	100.00	383.11	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	82.98	100.00		
Production Cost :	0.00	1586.51	100.00	1544.79	41.72
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	19.00	100.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	1969.62	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	1969.62			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	6.00
Profits/(Loss) :	0.00	(-1969.62)

Mis d/B
u
11.13

Date: Monday, 14/11/2005 8:50:14 AM
 User: Alba Panzuto

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FUEL PURGE CANISTER
Job Number :	23284		
Estimate Number :	10440		
P.O. Number :		Part Number :	D3262041
This Issue :	14/11/2005	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3262 REV B
First Issue :	/ /	Project Number :	
Previous Run :		Drawing Revision :	B
	Type :	Material :	
	MACHINED PARTS	Due Date :	30/11/2005
Written By :		Qty:	3
Checked & Approved By :		Um:	Each
Comment :	Est. C 05.03.10 Removed P/O for liquid penetrant inspection K J/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	23284A	FUEL PURGE CANISTER
-----	--------	---------------------



Comment: Sub-Component FUEL PURGE CANISTER

2.0	23284B	FUEL PURGE CANISTER
-----	--------	---------------------



Comment: Sub-Component FUEL PURGE CANISTER

3.0	D32621	Tube
-----	--------	------

4.0	D32623	Cap
-----	--------	-----

5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

Weld canister assembly as per Dwg D3262 using DT8739 to align fillings

Pick: Qty Part Number Description Batch

A/R Aluminum Rod

6.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

1-Inspect weld and work to Step 8

2-Pressurize canister to 10 psi and submerge under water and check for leaks as per Dwg D3262.

7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Date: Monday, 14/11/2005 8:50:14 AM
User: Alba Panzuto

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 23284

Part Number: D3262041

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

2-Ensure to mask threads

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: _____

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Date: Monday, 14/11/2005 8:50:16 AM
 User: Alba Panzuto

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FUEL PURGE CANISTER
Job Number	: 23284A		
Estimate Number	: 10441		
P.O. Number	:	Part Number	: D32621
This Issue	: 14/11/2005	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3262 REV B
First Issue	: / /	Project Number	:
Previous Run	:	Drawing Revision	: B
	Type : MACHINED PARTS	Material	:
Written By	:	Due Date	: 30/11/2005
Checked & Approved By	:	Qty:	3 Um: Each
Comment	: Est. C 05.03.10 Removed P/O for liquid penetrant inspection K J/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T5000W125	6061-T6 Tube 5.00X.125W
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2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut D3262-1 to length as per Dwg D3262

Identify as D3262-1

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

6.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

Ensure to mask threads

Date: Monday, 14/11/2005 8:50:16 AM
User: Alba Panzuto

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 23284A

Part Number: D32621

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: _____

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Date: Monday, 14/11/2005 8:50:18 AM
 User: Alba Panzuto

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FUEL PURGE CANISTER
Job Number	: 23284B		
Estimate Number	: 10442		
P.O. Number	:	Part Number	: D32623
This Issue	: 14/11/2005 S.O. No. :	Drawing Number	: D3262 REV B
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	:	Material	:
Written By	:	Due Date	: 30/11/2005 Qty: 6 Um: Each
Checked & Approved By	:		
Comment	: Est. C 05.03.10 Removed P/O for liquid penetrant inspection K J/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Cut blanks: 6.000" x 0.500" x 5.400" long Bar Machine as per Folio FA457 and Dwg D3262 Identify for D3262-3 Deburr		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		
6.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3 Ensure to mask threads		

Date: Monday, 14/11/2005 8:50:18 AM
User: Alba Panzuto

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 23284B

Part Number: D32623

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: _____

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

